

# Work Order ID 107790

Wednesday, October 02, 2013 8:59:07 AM

**\*107790\***

Page 1

Item ID: D412-711-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Vertical Reference Door Installation LH  
 Start Date: 10/2/2013 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 10/11/2013 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: CL Date: 13/10/02 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
N/A	Rev N/A								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefiles and create labels per PPP D412-711-011 CHG002								<u>CL 13/10/02</u> (1)
110		0.00							
<b>*110*</b>	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>21552</u> to Eagle Copters" Assembly of D412-711-011 Door Send a copy of this IPP								<u>CL 13/10/02</u> (1)
120		0.00							
<b>*120*</b>	Purchasing								
Purchasing	Memo	0.00							
Purchasing	EAGLEPick:QtyPart NumberDescriptionBatch1204-030-853-119LH Co- pilot Door Attach serviceable tags2-EAGLEFabricate/Pick the following parts to go into the door in accordance with: D2046902 Sheet 1 Rev. 3D2046902 Sheet 2 R								

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY										
<b>Landing Gear</b>			<b>General</b>			<b>Grain</b>		<b>Other</b>		
<input type="checkbox"/> Bending	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Cracks	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Wave/Twist in Tube
<input type="checkbox"/> Bend	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Burrs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Countersink	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Drawing	<input type="checkbox"/> Finish	<input type="checkbox"/> Folio
<input type="checkbox"/> Grain	<input type="checkbox"/> Hardware	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Misread	<input type="checkbox"/> Offset	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ovalized	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> Temperature/Cure	<input type="checkbox"/> Weld	<input type="checkbox"/> Wrong Stock Pulled
								<input type="checkbox"/> Other		

**Work Order ID 107790**

Wednesday, October 02, 2013 8:59:07 AM

**\*107790\***

Page 2

**Item ID:** D412-711-011

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

**Revision ID:**

Stop \*NS2\*

**Item Name:** Vertical Reference Door Installation LH

**Start Date:** 10/2/2013      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date: 10/11/2013    Req'd Qty: 1.00    \*1\***

**Customer:**

### Reference:

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC4- 100% Inspect kits for completeness

0.00

**\*130\***

0.00

QC

## Memo

## Quality Control

**Eagle- Send this W/O back to DartKit to be stocked at Eagle**

140

QC5- Inspect part completeness to step on W/O	0.00
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0.00

**\*140\***

0.00

QC

## Memo

## Quality Control

150

Identify as per dwg & Stock Location:\_\_\_\_\_ 0.00

0.00

**\*150\***

0.00

### Packaging

## Memo

## Packaging

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>						
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
<b>FAULT CATEGORY</b>												
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  _____ _____ _____		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other _____ _____ _____	

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Page 3

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Item ID: D412-711-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Vertical Reference Door Installation LH

Start Date: 10/2/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

CL 13/11/13

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other		

# Picklist Print

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Page 1

Work Order ID: 107790

Parent Item: D412-711-011

Start Date: 10/2/2013

Required Date: 10/11/2013

Parent Item Name: Vertical Reference Door Installation LH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.09.29New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-711-041P Vertical Reference Door		Purchased	No				Each	0.0000		1			
EA20469-15-412 Instrument Panel, 412		Manufactured	No			110	Each	0.0000	1	1			
D412-711-101 Replacement Vertical Reference Window		Manufactured	No			120	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG090		4							
				101695		1							
				106386		2							
				94691		1							
				FG091		1							
				102127		1							
D412-711-111 Wiring Harness For Vertical Reference Door		Manufactured	No			120	Each	0.0000	1	1			

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 107790

Wednesday, October 02, 2013 9:10:37 AM

\*107790\*

Page 1

Item ID: D412-711-011 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Vertical Reference Door Installation LH  
 Start Date: 10/2/2013 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 10/11/2013 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100		0.00							
*100*	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefiles and create labels per PPP D412-711-011 CHG002								

DAS  
42 NOV 12 2013

110		0.00							
*110*	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 21552 to Eagle Copters" Assembly of D412-711-011								
	Door Send a copy of this IPP								

DAS  
42 NOV 12 2013

120		0.00							
*120*	Purchasing								
Purchasing	Memo	0.00							
Purchasing	EAGLE Pick: Qty Part Number Description Batch 1204-030-853-119LH Co- pilot Door 4050577 Attach serviceable tags 2-EAGLE Fabricate/Pick the following parts to go into the door in accordance with: D2046902 Sheet 1 Rev. 3D2046902 Sheet 2 R								

NOV 12 2013

**Work Order ID 107790****\*107790\***

Page 2

Wednesday, October 02, 2013 9:10:37 AM

Item ID: D412-711-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Vertical Reference Door Installation LH

Start Date: 10/2/2013 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC4- 100% Inspect kits for completeness

0.00

**\*130\***


QC

Memo

0.00

Quality Control

Eagle- Send this W/O back to DartKit to be stocked at Eagle

 **DAS**  
42  
9-89 NOV 12 2013

140

QCS- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

 **DAS**  
42  
9-89 NOV 12 2013

150

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00


**\*150\***

Packaging

Memo

0.00

Packaging

 **DAS**  
42  
9-89 NOV 12 2013

**Work Order ID 107790****\*107790\***

Page 3

Wednesday, October 02, 2013 9:10:37 AM

Item ID: D412-711-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Vertical Reference Door Installation LH

Start Date: 10/2/2013 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

# Picklist Print

Page 1

Wednesday, October 02, 2013 9:10:54 AM

Work Order ID: 107790

Parent Item: D412-711-011

Parent Item Name: Vertical Reference Door Installation LH

Start Date: 10/2/2013

Required Date: 10/11/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.09.29New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-711-041P Vertical Reference Door		Purchased	No	WO 50577			Each	0.0000				NOV 12 2013	
EA20469-15-412 Instrument Panel, 412		Manufactured	No	WO 50577		110	Each	0.0000		1		NOV 12 2013	
D412-711-101 Replacement Vertical Reference Window		Manufactured	No	WO 50577		120	Each	5.0000		1		NOV 12 2013	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				PG090		4							
				101695		1							
				106386		2							
				94691		1							
				PG091		1							
				102127		1							
D412-711-111 Wiring Harness For Vertical Reference Door		Manufactured	No	WO 50577		120	Each	0.0000		1		NOV 12 2013	

Work Order Number: 50577

Modify LH Crew Door

*This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.*

Item: 1 L/H DOOR ASSEMBLY

## Squawk: 1.1

### Discrepancy:

LH Crew Door, Modify

### Resolution:

L/H door modified to VRD  
IAW Dwg D20446901 Rev  
6,  
STC SH92-55

1.1 Work Done By: Colin Gould

*The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*  
AMO 6-81 Signature: Colin Gould on 11/12/2013

### Parts:

Part Number	Description	Serial Number	Lot Number	Condition	Qty
D412-711-021	Vertical Reference Door Modification Kit LH		LT-13-014147	New	1
D4268-3	INSTRUMENT PANEL (212)		LT-13-003537	New	1
MS20392-1S39	PIN		LT-007494	New	1
MS20392-1S25	PIN		LT-12-006615	New	1
MS24693S51	SCREW		LT-12-006226	New	12
NAS561P2-6	PIN		LT-13-009139	New	1
412-110-103	DOOR HANDLE W/LOCK		LT-13-007329	New	1
110-070-41	SEAL		LT-13-014433	New	14

## Squawk: 1.2

### Discrepancy:

Media blast, prep and paint  
L/H door

### Resolution:

Media blasted in  
accordance with the Bell  
SPM Chapter 3  
Painted exterior super white  
Glasurit 22 Line under EAG  
in C/C  
Interior Light Interior Grey  
Glasurit 22 Line under EAG  
C/C

1.2 Work Done By: Michael McAllister

*The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*  
AMO 6-81 Signature: Michael McAllister on 11/12/2013

\*\*\*\*\* Original Maintenance Releases and Independent Control Inspection details are stored electronically at \*\*\*\*\*  
\*\*\*\*\* Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software \*\*\*\*\*

Work Order Number: 50577

Modify LH Crew Door

*This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.***Squawk: 1.3****Discrepancy:**

Assemble Wiring Assy ref.  
drawing D2046903 Rev.0  
IAW STC SH92-30 Issue 3.

**Resolution:**

Assembled Wiring Assy ref.  
drawing D2046903 Rev.0  
IAW STC SH92-30 Issue 3.

**1.3 Work Done By: CAROL ROBINSON**


*The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*  
**AMO 6-81** Signature: Graeme Rowe on 10/31/2013

**Parts:**

Part Number	Description	Serial Number	Lot Number	Condition	Qty
MS3126E8-33SW	CONNECTOR		LT-13-003408	New	1
MS3126E10-6S	CONNECTOR		LT-13-006655.1	New	1
MS3126E8-33S	CONNECTOR		LT-13-000380	New	1
MS3126E12-10S	CONNECTOR		LT-13-015577	New	1
MS3126E12-10S	CONNECTOR		LT-13-015577	New	1
MS3126E12-10SW	CONNECTOR		LT-13-011666	New	1
MS3120E8-33PW	Connector		LT-12-008682	New	1
MS3120E10-6P	CONNECTOR		LT-08-018590	New	1
MS3120E8-33P	Connector		LT-13-015433	New	1
MS3120E12-10P	CONNECTOR		LT-13-015432	New	1
MS3120E12-10PW	CONNECTOR		LT-12-008596	New	1
126-195	CONNECTOR		LT-12-005363	New	1
126-198	Connector		LT-13-015845	New	1
MS25041-8	INDICATOR LIGHT		LT-13-015819	New	1
MS25041-6	LIGHT, INDICATOR		LT-13-006525	New	2
XPF-1/4	EXPANDABLE SLEEVING		LT-13-001644.5	New	8
XPF-3/4	EXPANDABLE SLEEVE		LT-12-009422	New	8
M22759/41-20-9	WIRE		LT-12-012212	New	66
M22759/41-22-9	WIRE		LT-13-009038	New	297
327	LIGHT BULB		LT-13-005219	New	3

\* End of Report \*

\*\*\*\*\* Original Maintenance Releases and Independent Control Inspection details are stored electronically at \*\*\*\*\*  
\*\*\*\*\* Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software \*\*\*\*\*

1. Approving National Authority/Country <b>Transport Canada</b>		<b>Authorized Release Certificate</b> <b>FORM ONE</b>		3. Form Tracking Number <b>50577.1</b>	
4. Approved Organization Name and Address <b>Eagle Copters Maintenance Ltd.</b> <b>823 McTavish Road NE,</b> <b>Calgary, Alberta, Canada, T2E 7G9</b>				5. Work Order/Contract/Invoice <b>50577</b>  <b>TCCA AMO Number 6-81</b> <b>EASA Approval Number 145.7028</b> <b>Chilean Approval Number 333</b>	
6. Item <b>1</b>	7. Description <b>Door</b>	8. Part Number <b>204-030-853-125</b>	9. Quantity <b>1</b>	10. Serial Number/ Lot Number <b>N/A</b>	11. Status/Work <b>Modified</b>
12. Remarks  <b>L/H door modified to VRD IAW Dwg D20446901 Rev 6 ,STC SH92-55</b>  Time Since New: <u><b>Unknown</b></u> Time Since Overhaul: <u><b>Unknown</b></u> Other: <u><b>N/A</b></u>					
<del>13a. Certifies that the items identified above were manufactured in conformity to: Approved Design data and are in condition for safe operation Non-approved design data specified in block 13</del>			14a. <input checked="" type="checkbox"/> <b>CAR 571.10 Maintenance Release</b> <input type="checkbox"/> <b>Other regulations specified in block 12</b> Certifies that, unless otherwise specified in block 12, the work identified in block 11 and described in block 12 has been performed in compliance with the Canadian Aviation Regulations		
<del>13b. Authorized Signature</del>		<del>13c. Certificate/Approval Number</del>		14b. Authorized Signature: 	
<del>13d. Name</del>		<del>13e. Date</del>		14c. Certificate/Approval Number: <b>TC AMO Approval No. 6-81</b>  14d. Name: <b>Colin Gould</b>  14e. Date (mm/dd/yyyy) <b>11/07/2013</b>	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a and 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

**Work Order ID 107790**

Wednesday, October 02, 2013 9:10:37 AM

**\*107790\***

Page 1

Item ID: D412-711-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Vertical Reference Door Installation LH  
Start Date: 10/2/2013 Start Qty: 1.00 \*1\* Cust Item ID:  
Required Date: 10/11/2013 Req'd Qty: 1.00 \*1\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
N/A	Rev N/A								

100 0.00  
**\*100\*** DOCUMENT CONTROL  
DC Memo 0.00  
Document Control Photocopy bluefiles and create labels per PPP D412-711-011 CHG002

DAS  
42 NOV 12 2013  
9:59

110 0.00  
**\*110\*** PURCHASING  
Purchasing Memo 0.00  
Purchasing Issue P/O: 21552 to Eagle Copters" Assembly of D412-711-011  
Door Send a copy of this IPP

DAS  
42 NOV 12 2013  
9:59

120 0.00  
**\*120\*** Purchasing  
Purchasing Memo 0.00  
Purchasing EAGLEPick:QtyPart NumberDescriptionBatch1204-030-853-119LH Co-  
pilot Door W050577 Attach serviceable tags2-EAGLEFabricate/Pick  
the following parts to go into the door in accordance with: D2046902  
Sheet 1 Rev. 3D2046902 Sheet 2 R

NOV 12 2013



**Work Order ID 107790**

Wednesday, October 02, 2013 9:10:37 AM




**\*107790\***

Page 2

Item ID: D412-711-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Vertical Reference Door Installation LH  
Start Date: 10/2/2013 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 10/11/2013 Req'd Qty: 1.00 **\*1\*** Customer:

**Reference:**

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo Eagle- Send this W/O back to DartKit to be stocked at Eagle	0.00  0.00				 <b>DAS</b> <b>42</b> <b>9-89</b>		NOV 12 2013	
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				 <b>DAS</b> <b>42</b> <b>9-89</b>		NOV 12 2013	
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00				 <b>DAS</b> <b>42</b> <b>9-89</b>		NOV 12 2013	

Wednesday, October 02, 2013 9:10:37 AM

Page 3

### Quality Control

# Picklist Print

Wednesday, October 02, 2013 9:10:54 AM

Page 1

Work Order ID: 107790

Parent Item: D412-711-011

Start Date: 10/2/2013

Required Date: 10/11/2013

Parent Item Name: Vertical Reference Door Installation LH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.09.29New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-711-041P Vertical Reference Door		Purchased	No	WO 50577			Each	0.0000				NOV 1 2 2013	
EA20469-15-412 Instrument Panel, 412		Manufactured	No	WO 50577		110	Each	0.0000				NOV 1 2 2013	
D412-711-101 Replacement Vertical Reference Window		Manufactured	No	WO 50577		120	Each	5.0000				NOV 1 2 2013	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG090		4							
				101695		1							
				106386		2							
				94691		1							
				FG091		1							
				102127		1							
D412-711-111 Wiring Harness For Vertical Reference Door		Manufactured	No	WO 50577		120	Each	0.0000				NOV 1 2 2013	

Work Order Number: 50577

Modify LH Crew Door

*This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.*

Item: 1 L/H DOOR ASSEMBLY

**Squawk: 1.1**Discrepancy:

LH Crew Door, Modify

Resolution:L/H door modified to VRD  
IAW Dwg D20446901 Rev  
6,  
STC SH92-55**1.1** Work Done By: Colin Gould***The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*****AMO 6-81** Signature: Colin Gould on 11/12/2013Parts:

Part Number	Description	Serial Number	Lot Number	Condition	Qty
D412-711-021	Vertical Reference Door Modification Kit LH		LT-13-014147	New	1
D4268-3	INSTRUMENT PANEL (212)		LT-13-003537	New	1
MS20392-1S39	PIN		LT-007494	New	1
MS20392-1S25	PIN		LT-12-006615	New	1
MS24693S51	SCREW		LT-12-006226	New	12
NAS561P2-6	PIN		LT-13-009139	New	1
412-110-103	DOOR HANDLE W/LOCK		LT-13-007329	New	1
110-070-41	SEAL		LT-13-014433	New	14

**Squawk: 1.2**Discrepancy:Media blast, prep and paint  
L/H doorResolution:Media blasted in  
accordance with the Bell  
SPM Chapter 3  
Painted exterior super white  
Glasurit 22 Line under EAG  
in C/C  
Interior Light Interior Grey  
Glasurit 22 Line under EAG  
C/C**1.2** Work Done By: Michael McAllister***The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*****AMO 6-81** Signature: Michael McAllister on 11/12/2013

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Work Order Number: 50577

Modify LH Crew Door

*This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.***Squawk: 1.3**Discrepancy:

Assemble Wiring Assy ref.  
drawing D2046903 Rev.0  
IAW STC SH92-30 Issue 3.

Resolution:

Assembled Wiring Assy ref.  
drawing D2046903 Rev.0  
IAW STC SH92-30 Issue 3.

**1.3** Work Done By: CAROL ROBINSON***The maintenance described above has been performed in accordance with the applicable standards of airworthiness.*****AMO 6-81** Signature: Graeme Rowe on 10/31/2013Parts:

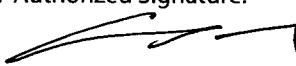

Part Number	Description	Serial Number	Lot Number	Condition	Qty
MS3126E8-33SW	CONNECTOR		LT-13-003408	New	1
MS3126E10-6S	CONNECTOR		LT-13-006655.1	New	1
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126-198	Connector		LT-13-015845	New	1
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MS25041-6	LIGHT, INDICATOR		LT-13-006525	New	2
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\* End of Report \*

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1. Approving National Authority/Country <b>Transport Canada</b>		<b>Authorized Release Certificate</b> <b>FORM ONE</b>		3. Form Tracking Number <b>50577.1</b>	
4. Approved Organization Name and Address <b>Eagle Copters Maintenance Ltd.</b> <b>823 McTavish Road NE,</b> <b>Calgary, Alberta, Canada, T2E 7G9</b>				5. Work Order/Contract/Invoice <b>50577</b>	
6. Item <b>1</b>	7. Description <b>Door</b>	8. Part Number <b>204-030-853-125</b>	9. Quantity <b>1</b>	10. Serial Number/ Lot Number <b>N/A</b>	11. Status/Work <b>Modified</b>
12. Remarks  L/H door modified to VRD IAW Dwg D20446901 Rev 6 ,STC SH92-55  Time Since New: <u><b>Unknown</b></u> Time Since Overhaul: <u><b>Unknown</b></u> Other: <u><b>N/A</b></u>					
<del>13a. Certifies that the items identified above were manufactured in conformity to: Approved Design data and are in condition for safe operation Non approved design data specified in block 13</del>			14a. <input checked="" type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in block 12 Certifies that, unless otherwise specified in block 12, the work identified in block 11 and described in block 12 has been performed in compliance with the Canadian Aviation Regulations		
<del>13b. Authorized Signature</del>		<del>13c. Certificate/Approval Number</del>		14b. Authorized Signature:  	
<del>13d. Name</del>		<del>13e. Date</del>		14c. Certificate/Approval Number: <b>TC AMO Approval No. 6-81</b>  14d. Name: <b>Colin Gould</b>  14e. Date (mm/dd/yyyy) <b>11/07/2013</b>	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a and 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					